

Work Order ID 5555

January 27, 2010 9:21:27 AM

Page 1

Item ID: D4005-1

Accept

Revision ID:

Item Name: Aft Restraint Angle/Fuel Gutter

Start Date: 1/27/10 Start Qty: 2.00

Required Date: 2/02/10 Req'd Qty: 2.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date: 1-1-27

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4005

A-PRELIM

Now Rev. A

0.00

100

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg

Dwg Rev: PRE

Prog Rev: Lim

2-Deburr if necessary

18 10-1-27

(4)

110

QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Memo

0.00

Quality Control

18 10-1-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 55655

January 27, 2010 9:21:27 AM



Page 2

Item ID: D4005-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Aft Restraint Angle/Fuel Gutter

Start Date: 1/27/10 Start Qty: 2.00



Cust Item ID:

Required Date: 2/02/10 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals: Process Plan: Date: Tooling: Date:

Stop



QC: Date: SPC (Y/N): Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

120 QC8- Inspect parts - second check

0.00

⇒ 81010128



QC

Memo

0.00

(K4)

Quality Control

130 Bend as per dwg

0.00

SD 1010128



Brake NC

Memo

0.00

(4)

Brake NC

140

QC5 inspect

⇒ 81010128

(K4)

PE

130 Chemical Conversion Coat per QS1005 4.1

0.00



HandFinish

Memo

0.00

OK 10-02-01

(4)

Hand Finishing

145

100.08.25

powder coat as per
dwg

Start: _____

Over temp: _____

Finish: _____

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 55655

January 27, 2010 9:21:27 AM



Page 3

Item ID:	D4005-1	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Aft Restraint Angle/Fuel Gutter					
Start Date:	1/27/10	Start Qty:	2.00	Cust Item ID:		
Required Date:	2/02/10	Req'd Qty:	2.00	Customer:		
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 QC Quality Control	QC5 Inspect part completeness to step on W/O <i>QC3</i> Memo	0.00 0.00	<i>16-02-01</i>		<i>(X4)</i>		<i>Ø</i>		
<i>pro</i> →									
170 Packaging Packaging	Identify as per dwg & Stock Location: Memo	0.00 0.00							
180 QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							

POSITIVE RECALL
 EFFECTIVE *10-21-27* AUTH *U*
 RELEASED *7* DATE *10-26-28*
MF
10-2-19
CR44

W/O: 55655		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
10.06.28	160	complete ass'y per detail e on Rev. A chng. - P 2856-100-11 abrasion strip B 37438						
		add change 2 per m change QCS →		11.01.11		100628	100628	

Part No: D4005-1 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

January 27, 2010 9:21:31 AM

Page 1

Work Order ID: 55655



Parent Item: D4005-1



Parent Item Name: Aft Restraint Angle/Fuel Gutter

Start Date: 1/27/10

Required Date: 2/02/10

Comments: IPP rev A 10.01.21 new issue Prelim EC verified by:DD

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M2024T3S.063		Purchased		No		100	sf	22.9696	0.2902	.6		



2024-T3 .063 sheet



B 10-1-27

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

22.96962419

102942

1.5

105916

1.09

109463

0.00947368

110980

5.4854

111787

12.8847505

19059

2

111787

④

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

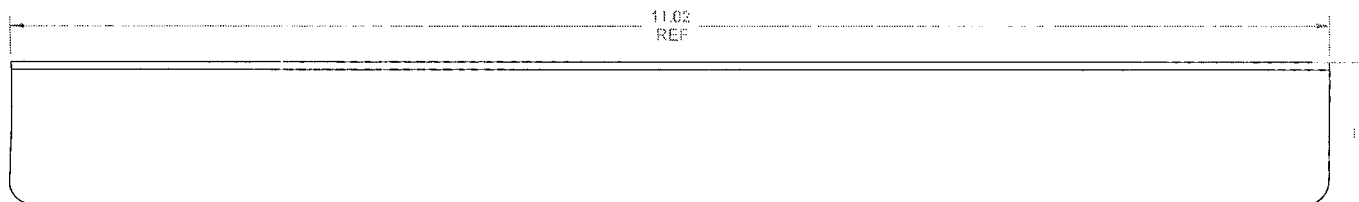
NOTE: Date & initial all entries

DART AEROSPACE
PART NUMBER

D4005-1

JOHN CAMERON AVIATION
PART NUMBER

JCA-M47-2-03



R0.19

D4005-1 AFT RESTRAINT ANGLE/FUEL GUTTER

See Rev A

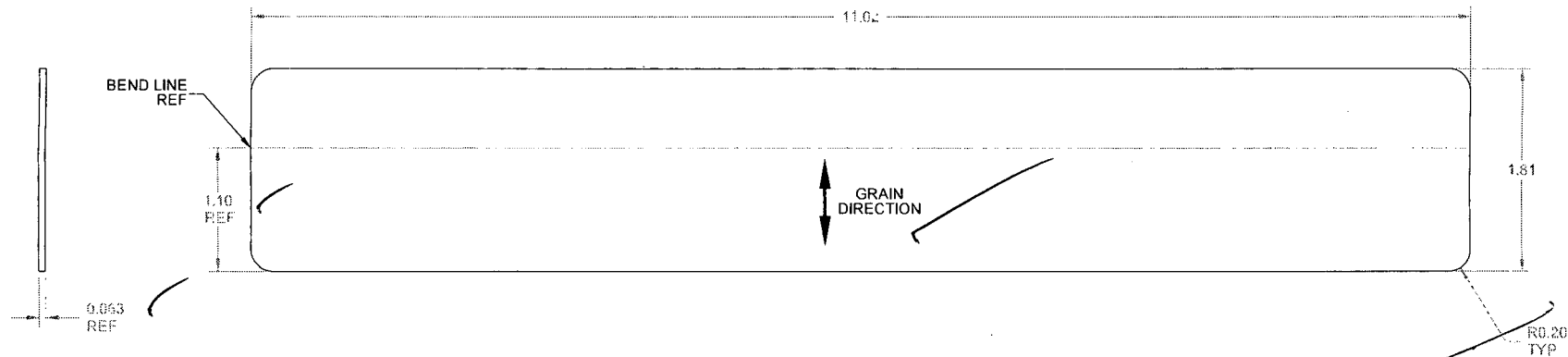
PRELIMINARY ISSUE

09.10.19

NOTES:

- 1) MATERIAL: MADE FROM D4005-1F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4005-1" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.12 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. PA1
MFG. APPR.		D4005	SHEET 2 OF 15
APPROVED		TITLE	SCALE
DE APPR.		FORWARD RESTRAINT	NTS
DATE	09.10.19	<small> COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD </small>	



D4005-1F FLAT PATTERN

See Rev. A

NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.063 THICK
PER QQ-A-250/4 OR AMS-QQ-A-250/4
OR AMS 4037 OR ASTM B209
REF DART SPEC M2024T3S.063
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.12 lbs

PRELIMINARY ISSUE

09.10.19

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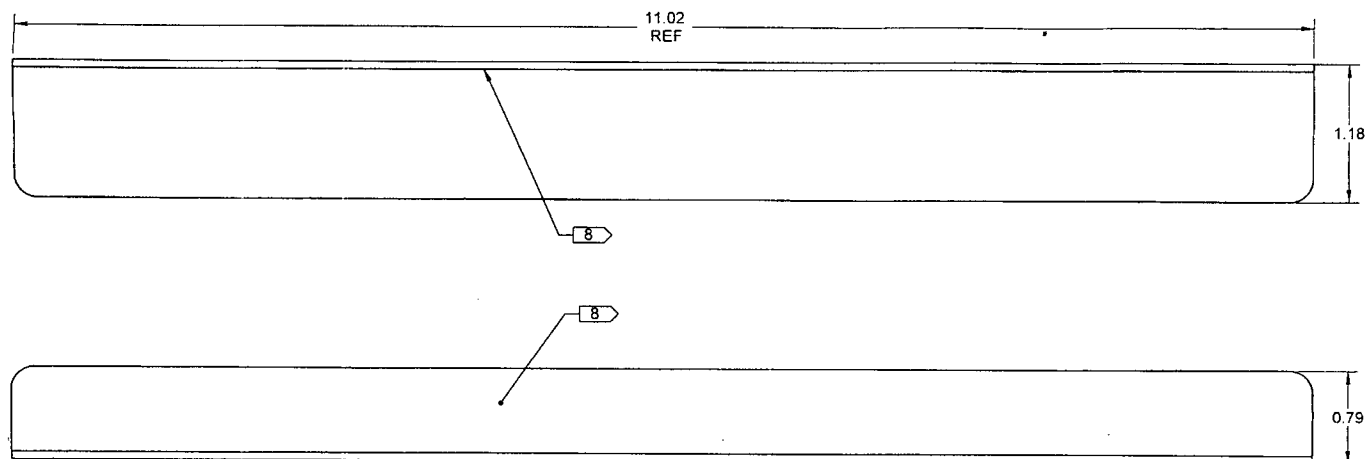
DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D4005-1	JCA-M47-2-03

D

C

B

A









D4005-1 REAR RESTRAINT ANGLE GUTTER

RELEASED
R 2010-05-05
MP

NOTES:

- 1) MATERIAL: MADE FROM D4005-1F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "GREY SANTEX" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4005-1" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.12 lbs
- 8) COVER THIS SURFACE WITH D2856-100-11 ABRASION STRIP. TRIM EXCESS

W1055655

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8

7

6

5

4

3

2

1

A

8 7 6 5 4 3 2 1

D

C

B

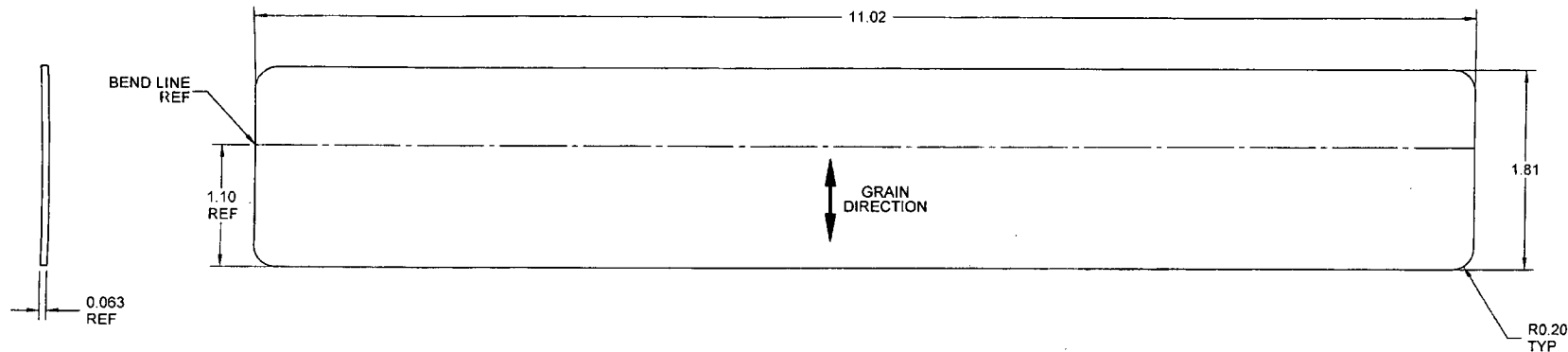
A

D

C

B

A



D4005-1F FLAT PATTERN

RELEASED
2010-05-05
W

W10 55655

- NOTES:
- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.063 THICK
PER QQ-A-250/4 OR AMS-QQ-A-250/4
OR AMS 4037 OR ASTM B209
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